

Date: Wednesday, 12/11/2008 1:41:34 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 43396	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 41613	Material :
Written By :	Due Date : 10/12/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JLD 08.11.12</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6102013	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 6061-T6 7.0x6.5x2.0 350 Saddle Billet Batch: <u>B41962</u> <u>J.F. 08/11/17</u> (12)		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>J.F.</u> Double check by: <u>SP</u> 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets 4-Deburr 5-Tumble to remove sharp edges. <u>mf / J.F. 08/11/17</u> (12)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>mf / J.F. 08/11/18</u> (12)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>24 08/11/00</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:34 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 43396

Part Number: D35001

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MD

08-11-20

(X12)

6.0

POWDER COATING

POWDER COATING



M109152



(12X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
323 OF
8:45

MD 08/11/21

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 8/11/24 (12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

(51437)

PC 8/11/24 (12)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43390
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.486	.486	.487		
B	1.175	1.185		1.179	1.179	1.180	1.178		
C	3.145	3.155		3.149	3.150	3.150	3.148		
D	1.175	1.185		1.180	1.179	1.180	1.178		
E	0.365	0.385		.371	.371	.373	.372		
F	0.490	0.510		.494	.500	.500	.500		
H									
I	R1.575	R1.595		R1.591	R1.592	1.590	1.594		
J	0.240	0.260		.242	.243	.240	.240		
K	0.490	0.510		.500	.499	.499	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.259	.259		
O	6.500	6.520		6.506	6.506	6.505	6.506		
P	5.990	6.010		6.006	6.006	6.005	6.006		
Q	2.820	2.830		2.830	2.830	2.830	2.830		
R	2.495	2.505		2.501	2.501	2.497	2.500		
S	2.245	2.255		2.255	2.252	2.256	2.249		
T	1.120	1.130		1.129	1.125	1.123	1.123		
U	0.540	0.560		.553	.554	.553	.556		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		R.250	R.250	.250	.250		
X	0.040	0.060		.055	.055	.053	.057		
Y	0.100	0.120		.110	.110	.115	.110		
AA	R1.125	R1.145		R1.137	R1.138	1.136	1.139		
AB	R.490	R.510		R.500	R.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.250	.250	.251	.251		
AE	1.810	1.830		1.818	1.820	1.816	1.819		
AF	0.240	0.260		.251	.250	.249	.251		
AG	0.140	0.160		.151	.151	.151	.153		
AH	0.140	0.160		.155	.152	.154	.154		
AI	0.140	0.160		.152	.150	.147	.151		
Accept/Reject									

Measured by: J.F.
Date: 08/11/17

Audited by: 120
Date: 08/11/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	

DART AEROSPACE LTD		Work Order: 43396	
Description: Saddle		Part Number: D3500-1	
Inspection Dwg: D3500		Rev: C	
		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.178	1.179	1.179	1.179		
C	3.145	3.155		3.149	3.149	3.150	3.150		
D	1.175	1.185		1.180	1.179	1.180	1.180		
E	0.365	0.385		.370	.370	.371	.371		
F	0.490	0.510		.500	.500	.498	.499		
H									
I	R1.575	R1.595		1.589	1.592	1.593	1.593		
J	0.240	0.260		.240	.240	.240	.240		
K	0.490	0.510		.499	.499	.499	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.321	.321	.321	.321		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.507	6.507	6.507	6.507		
P	5.990	6.010		6.007	6.005	6.005	6.007		
Q	2.820	2.830		2.828	2.829	2.828	2.828		
R	2.495	2.505		2.497	2.498	2.499	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.248		
T	1.120	1.130		1.122	1.123	1.124	1.122		
U	0.540	0.560		.557	.557	.556	.556		
V	0.793	0.803		.799	.799	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.102	.102	.110	.112		
AA	R1.125	R1.145		1.133	1.135	1.137	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.631	.631	.630		
AD	0.240	0.260		.252	.252	.252	.251		
AE	1.810	1.830		1.819	1.820	1.820	1.822		
AF	0.240	0.260		.248	.250	.251	.250		
AG	0.140	0.160		.150	.152	.152	.151		
AH	0.140	0.160		.154	.154	.154	.153		
AI	0.140	0.160		.146	.146	.147	.148		
Accept/Reject									

Measured by:	JMK
Date:	08/11/18

Audited by:	RQ
Date:	08/11/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	

DART AEROSPACE LTD		Work Order:	433910
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.149	3.149		
D	1.175	1.185		1.180	1.180	1.186	1.180		
E	0.365	0.385		.373	.373	.372	.372		
F	0.490	0.510		.500	.500	.500	.500		
H									
I	R1.575	R1.595		1.586	1.587	1.586	1.586		
J	0.240	0.260		.244	.244	.244	.244		
K	0.490	0.510		.501	.506	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.321	.321	.321	.321		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.507	6.507	6.507	6.507		
P	5.990	6.010		6.006	6.006	6.007	6.007		
Q	2.820	2.830		2.827	2.828	2.828	2.828		
R	2.495	2.505		2.498	2.500	2.499	2.499		
S	2.245	2.255		2.257	2.250	2.250	2.250		
T	1.120	1.130		1.129	1.121	1.125	1.125		
U	0.540	0.560		.553	.557	.557	.557		
V	0.793	0.803		.799	.798	.798	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.114	.111	.110	.110		
AA	R1.125	R1.145		1.129	1.130	1.131	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.256	.256	.256		
AE	1.810	1.830		1.819	1.819	1.821	1.820		
AF	0.240	0.260		.249	.250	.249	.250		
AG	0.140	0.160		.157	.152	.157	.157		
AH	0.140	0.160		.156	.160	.158	.158		
AI	0.140	0.160		.150	.153	.153	.153		
Accept/Reject									

Measured by:	Jef
Date:	08/11/18

Audited by:	Ra
Date:	08/11/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	

